

Work Order ID 54446

December 9, 2009 11:30:04 AM



Page 1

Item ID: D3304-5

Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket

Start Date: 09/12/2009 Start Qty: 20.00



Cust Item ID:

Required Date: 16/12/2009 Req'd Qty: 20.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

RL

Date:

09-12-9

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3304

Rev B

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3304 ☐ Dwg Rev: *B* ☐ Prog Rev: *B* ☐ 2-
Deburr if necessary

RB 9-12-10

09/12/11

(24)

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

RB 9-12-10

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

⇒ 8 01/12/11

counts
(X23)

P/b →

W/O: 54446		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
9/12/11	#120	Took Qty x1 For as as inspection template	S	07/12/11	x1	W	S 07/12/11

Part No: D3304-5 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 54446

December 9, 2009 11:30:04 AM



Page 2

Item ID: D3304-5

Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket

Start Date: 09/12/2009 Start Qty: 20.00



Cust Item ID:

Required Date: 16/12/2009 Req'd Qty: 20.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Brake NC Brake NC	NC BRAKE Memo 1-Deburr if necessary 2-Form as per Dwg D3304	0.00 0.00	80 09/12/17				23	0	
140 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00	27 02/12/17				countess 23		
150 Packaging Packaging	Identify as per dwg & Stock Location: <u>ench</u> Memo	0.00 0.00	9/12/18				23	SP	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

December 9, 2009 11:30:08 AM

Page 1

Work Order ID: 54446



Parent Item: D3304-5



Parent Item Name: Bracket


Start Date: 09/12/2009

Required Date: 16/12/2009

Comments:

Start Qty: 20.00

Required Qty: 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304S20GA  304/316 .040 Sheet		Purchased	No			100	sf	306.3536	1.2100			

1.452

189-10-10

(24)

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

306.3536158

110076

1.37053684

112567

38.0765789

112885

83.1578

113062

166.3723

113077

17.3764

109088

109088

110076 x 16 = .968

109088 x 8 = .484

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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D3304-044 TUBE ASSEMBLY (SHOWN)
D3304-043 OPPOSITE

D3304-041/-043/-044 NOTES:

- 1) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 2) WELD PER DART QSI 004
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) IDENTIFY AS INDICATED USING FINE POINT PERMANENT INK MARKER "TCCA-PDA, DART AEROSPACE LTD, P/N D3304-XXX B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA04-11"
- 7) IF BEING ASSEMBLED WITH D3303-041, ADD THE FOLLOWING USING A FINE POINT PERMANENT INK MARKER: "TCCA-PDA, DART AEROSPACE LTD, P/N D412-724-XXX B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA04-11"

DAFT

37 SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 54446

RE 04-12-9

DESIGN		DRAWN BY		REV. B	
RF		RF			
CHECKED		APPROVED		DRAWING NO.	
H		H		D3304	
DATE		TITLE		SHEET 1 OF 4	
05.07.15		TUBE ASSEMBLY		SCALE	
		1:6			
A		04.08.18		UPDATE DIMENSIONS: ADD D3304-7/-8	
B		05.07.15			

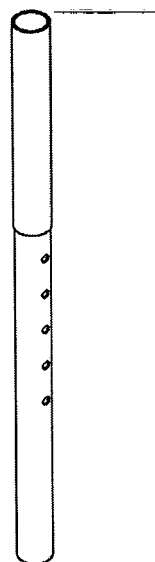
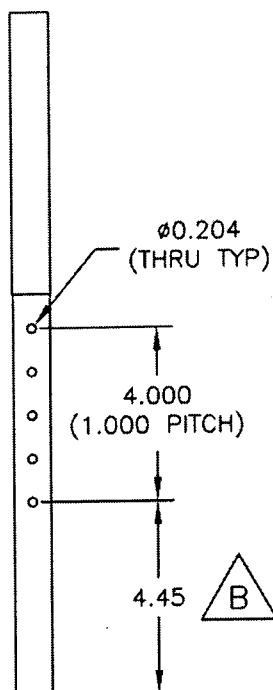
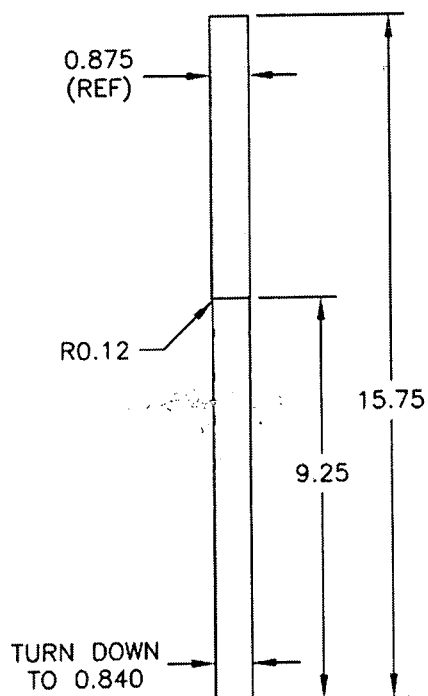
25-88-11-1



w/o 54446

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D3304	REV. B SHEET 2 OF 4
DATE 05.07.15		TITLE TUBE ASSEMBLY	SCALE 1:4

RELEASED
05.08.11



D3304-1 TUBE

D3304-1 NOTES:

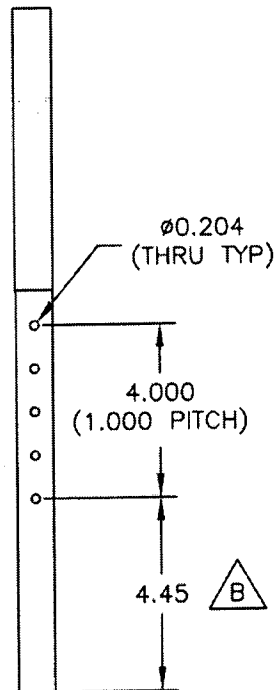
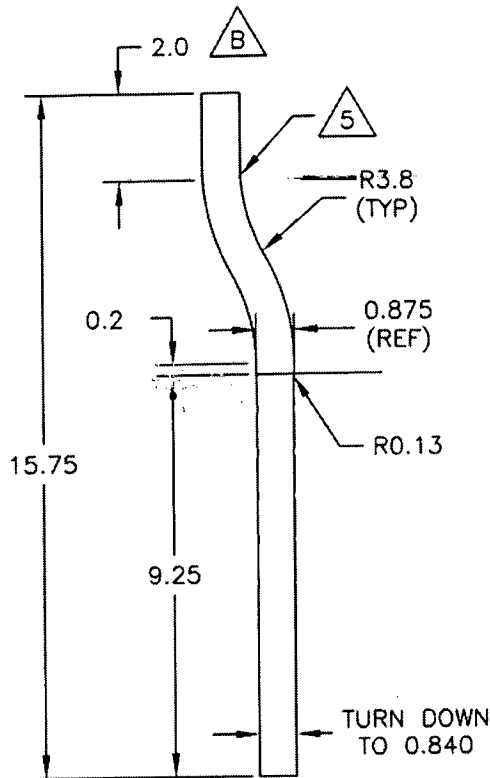
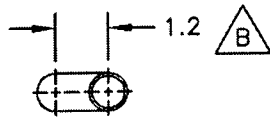
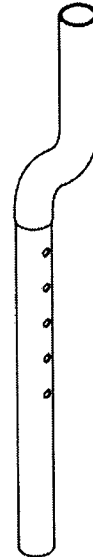
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL TUBE $\phi 0.875 \times 0.065$ WALL
(REF. DART SPEC M304TR0.875W.065) ENSURE SEAMLESS TUBE IS USED
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3304	REV. B SHEET 3 OF 4
DATE 05.07.15	TITLE TUBE ASSEMBLY		SCALE 1:4

**RELEASED**
05-08-11 *[Signature]***D3304-3 TUBE****D3304-3 NOTES:**

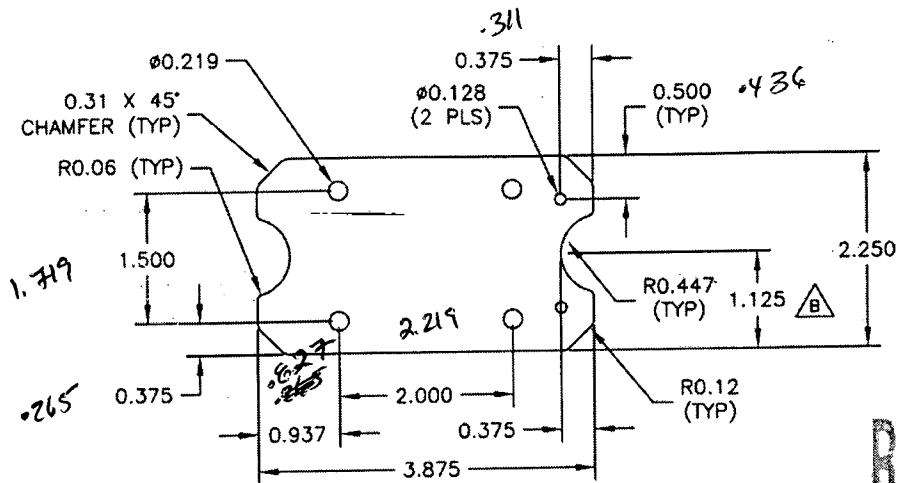
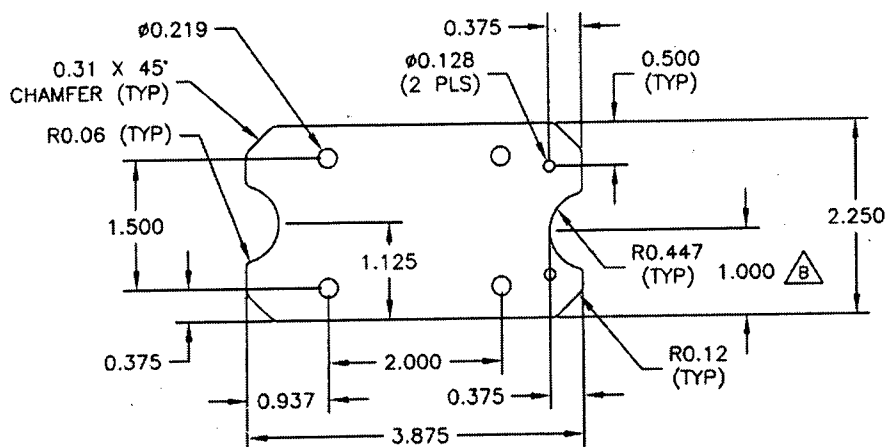
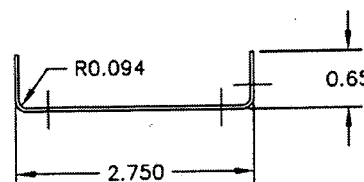
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL TUBE $\phi 0.875 \times 0.065$ WALL (REF. DART SPEC M304TR0.875W.065) ENSURE SEAMLESS TUBE IS USED
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) BEND LINES 9.625, 13.375 DIMENSIONS

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3304	REV. B SHEET 4 OF 4
DATE 05.07.15		TITLE TUBE ASSEMBLY	SCALE 1:2

**D3304-5 FLAT PATTERN****D3304-7/-8 FLAT PATTERN****D3304-5/-7 BRACKET
D3304-8 OPPOSITE****NOTES:**

- 1) MATERIAL: AISI 304/316 SS 0.040 THICK SHEET (REF. DART SPEC M304S20GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015

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